










Date: Monday, 11/21/2005 11:50:57 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 24847		
Estimate Number	: 10818		
P.O. Number	: NIA	Part Number	: D26651
This Issue	: 11/21/2005 S.O. No. : NIA	Drawing Number	: D2665 REV. B
Prsht Rev.	: NC	Project Number	: NIA
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: NIA	Material	: NIA
Written By	: SEE COMMENT BELOW	Due Date	: 12/21/2005 Qty: 12 Um: Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) B 24891 x 2 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no B22241 x 9 En / ml 05/12/30 12			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. En 05/12/28 1-Inspect part number and batch number are programmed correctly. J.L 05/12/28 2-Fixturing W/O No. NIA 3-Fixturing Inspection last completed on 05/12/28 by En 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet En / ml 05/12/30 12 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr En 06/01/14			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
			
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet En 06/01/14 12			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE En 06/01/14 12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 11:50:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 24847

Part Number: D26651

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/01/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:01:14

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06 01 30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CL 06/01/31 12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 343

CL 06/01/31 12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/01 12 PD 06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 24847
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.127	0.122	0.119		
B	0.100	0.140		0.123	0.121	0.127	0.117		
C	0.100	0.140		0.120	0.127	0.125	0.120		
D	0.210	0.230		0.219	0.223	0.221	0.217		
E	1.245	1.255		1.246	1.247	1.248	1.248		
F	1.245	1.255		1.246	1.249	1.248	1.248		
G	5.990	6.010		6.001	6.002	6.003	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.676	1.676	1.677	1.677		
J	2.495	2.505		2.495	2.497	2.500	2.500		
K	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.239	0.237	0.238	0.238		
N	0.100	0.140		0.112	0.112	0.105	0.122		
O	0.540	0.560		0.542	0.543	0.542	0.545		
P	0.490	0.510		0.499	0.494	0.496	0.496		
Q	3.609	3.619		3.610	3.610	3.609	3.609		
R	2.470	2.510		2.500	2.500	2.501	2.501		
S	0.240	0.270		0.251	0.251	0.253	0.245		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	0.313	0.318	DT8686	0.317	0.318	0.318	0.318		
V	1.125	1.145		1.132	1.130	1.127	1.139		
W	1.565	1.585		1.570	1.568	1.567	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ED
Date:	05/12/25

Audited by:	S.G
Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

0.265

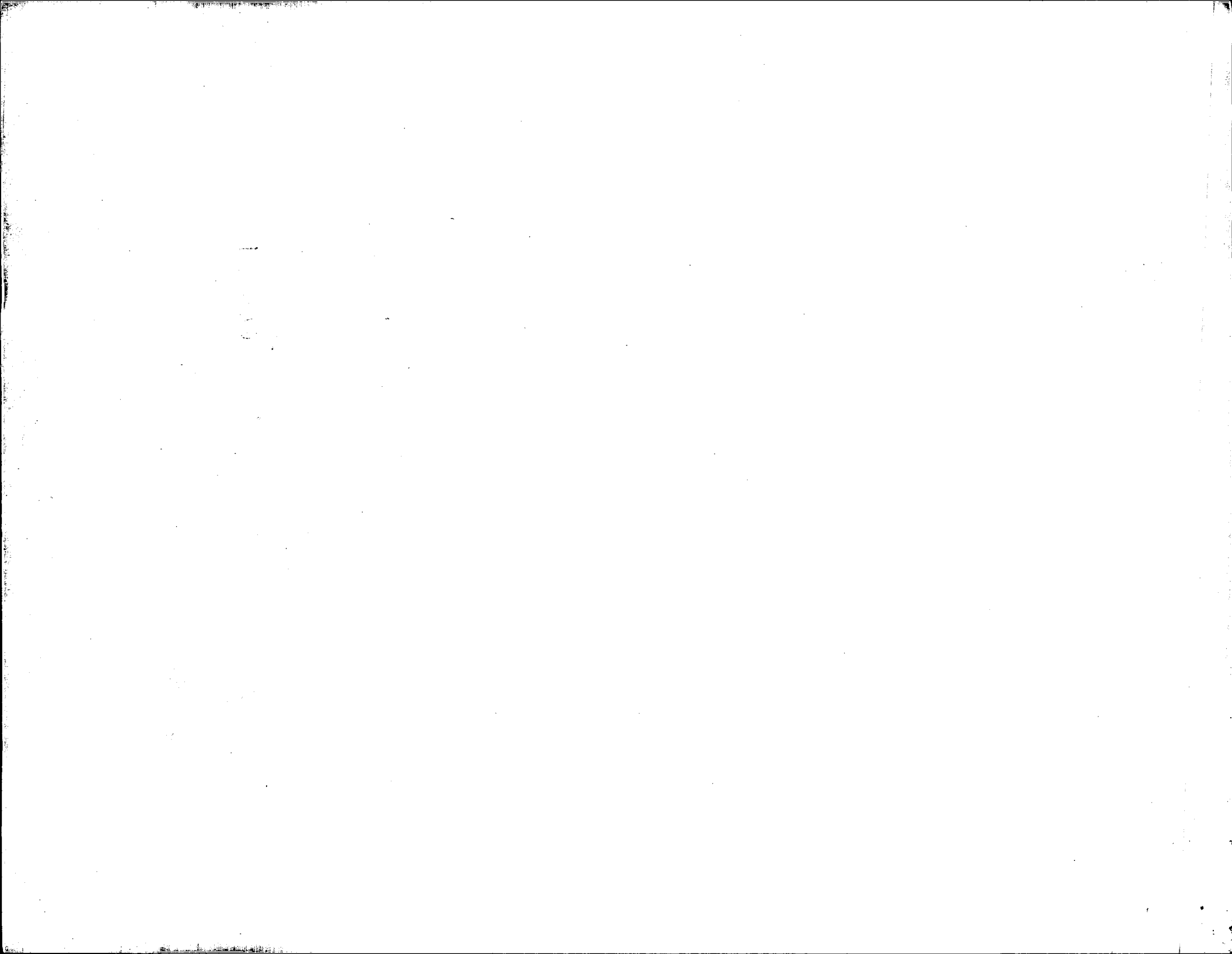
<b>ART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>24847</b>
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg:</b> D2665 Rev. B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.120	0.119	0.119		
B	0.100	0.140		0.122	0.120	0.126	0.121		
C	0.100	0.140		0.126	0.127	0.125	0.127		
D	0.210	0.230		0.218	0.220	0.220	0.220		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	5.990	6.010		6.000	6.001	6.001	6.001		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.679	1.679	1.680		
J	2.495	2.505		2.497	2.500	2.500	2.499		
K	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.120	0.121	0.122	0.121		
O	0.540	0.560		0.543	0.548	0.543	0.547		
P	0.490	0.510		0.502	0.504	0.503	0.506		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.499	2.495	2.499	2.496		
S	0.240	0.270		0.244	0.245	0.244	0.244		
T	0.100	0.180		0.144	0.140	0.145	0.141		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.137	1.138	1.138	1.140		
W	1.565	1.585		1.576	1.577	1.579	1.572		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>me</i>	Audited by:	<i>J. G</i>
Date:	05/12/30 / 06/01/14	Date:	06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat: Added Dim. U-W & DT8683, DT8686	K"RF	



<b>ART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>24877</b>
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg:</b> D2665 Rev. B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

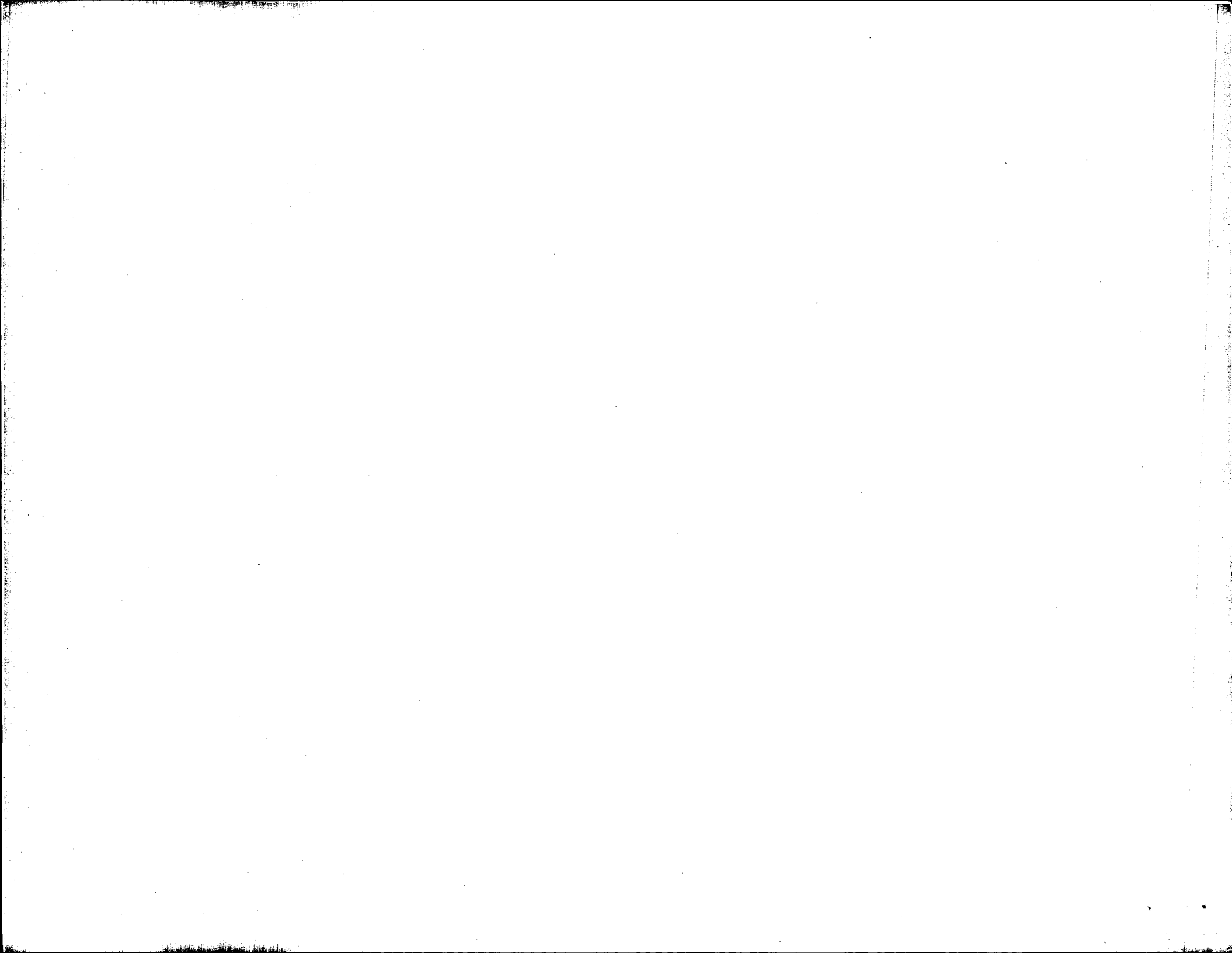
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.118	0.121	0.119		
B	0.100	0.140		0.120	0.118	0.118	0.121		
C	0.100	0.140		0.115	0.112	0.110	0.113		
D	0.210	0.230		0.220	0.221	0.221	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.250	1.251	1.250	1.250		
G	5.990	6.010		6.001	6.001	6.000	6.001		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.680	1.680	1.679	1.679		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.237	0.237		
N	0.100	0.140		0.120	0.121	0.120	0.120		
O	0.540	0.560		0.545	0.546	0.549	0.546		
P	0.490	0.510		0.504	0.501	0.505	0.504		
Q	3.609	3.619		3.611	3.612	3.612	3.612		
R	2.470	2.510		2.500	2.500	2.500	2.496		
S	0.240	0.270		0.244	0.244	0.244	0.244		
T	0.100	0.180		0.143	0.146	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.142	1.142	1.142	1.142		
W	1.565	1.585		1.577	1.575	1.576	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: [Signature]  
Date: 05/12/30 / 06/01/14

Audited by: J.G.  
Date: 06/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	





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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024847	Department Code:	
Project Name	: D2665-1	Burden Flags	: NNNNNNNN
Project For	: WK551	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2665-1	Invoice Number	:
Description	: Saddle, LH Fwd Aft Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-21-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00